

Date: Monday, 20/04/2009 1:00:04 PM
 User: Julie Dawson

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : STRUT
Job Number : 47295	
Estimate Number : 11557	
P.O. Number :	Part Number : D30841
This Issue : 20/04/2009 S.O. No. :	Drawing Number : D3084 REV A
Prsht Rev. : NC	Project Number : N/A
First Issue : // Type : LARGE FAB ASSY	Drawing Revision : A
Previous Run : 43164	Material :
Written By :	Due Date : 27/04/2009 Qty: 5 Um: Each
Checked & Approved By : <u>JUD 09 04 20</u>	
Comment : Est. C 02.05.11 Added welding rod batch number NG	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M6061T6T0750W058	6061-T6 RD Tube .750 x.058W
Comment: Qty.: 3.3249 f(s)/Unit Total : 13.2997 f(s) 6061-T6 Tube .750 x.058W Material: .750 Dia X .058 wall 6061-T6(ww-t-700/6)Seamless Aluminum tubing No: <u>410099</u>		
		SB 09/04/27 (S)
2.0	BAND SAW	BAND SAW
Comment: BAND SAW Punch per Dwg. D3084 and spec control dwg D2638 Open hole to .323ø as per dwg, one side only Deburr		
		SB 09/04/27 M-H 09/04/28 (S)
3.0	QC5	INSPECT WORK TO CURRENT STEP
Comment: INSPECT WORK TO CURRENT STEP		
		S 09/04/23 (S)
4.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1
Comment: LARGE FABRICATION RESOURCE 1 Weld ends per QSI 004. Use aluminum rod Grind flush. Batch: <u>M11385</u>		
		lpl 09.04.25 M-H 09/05/11 (S)
5.0	QC9	VISUAL WELDING INSPECTION
Comment: VISUAL WELDING INSPECTION		
		D 09.05.12

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 20/04/2009 1:00:05 PM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: STRUT

Job Number: 47295

Part Number: D30841

Job Number:



Seq. #: Machine Or Operation: Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



0505-12

(5)



Comment: INSPECT WORK TO CURRENT STEP

7.0

POWDER COATING

POWDER COATING



m 111472



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

(5)

START TIME:

9:05

OVEN TEMPERATURE:

320°

FINISH TIME:

9:35

FL 09/05/12

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



W



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

09-05-12

(X5)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

ST271

09/05/12

(X5)

10.0

QC21

FINAL INSPECTION/W/O RELEASE



09/05/13

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF
09-05-12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

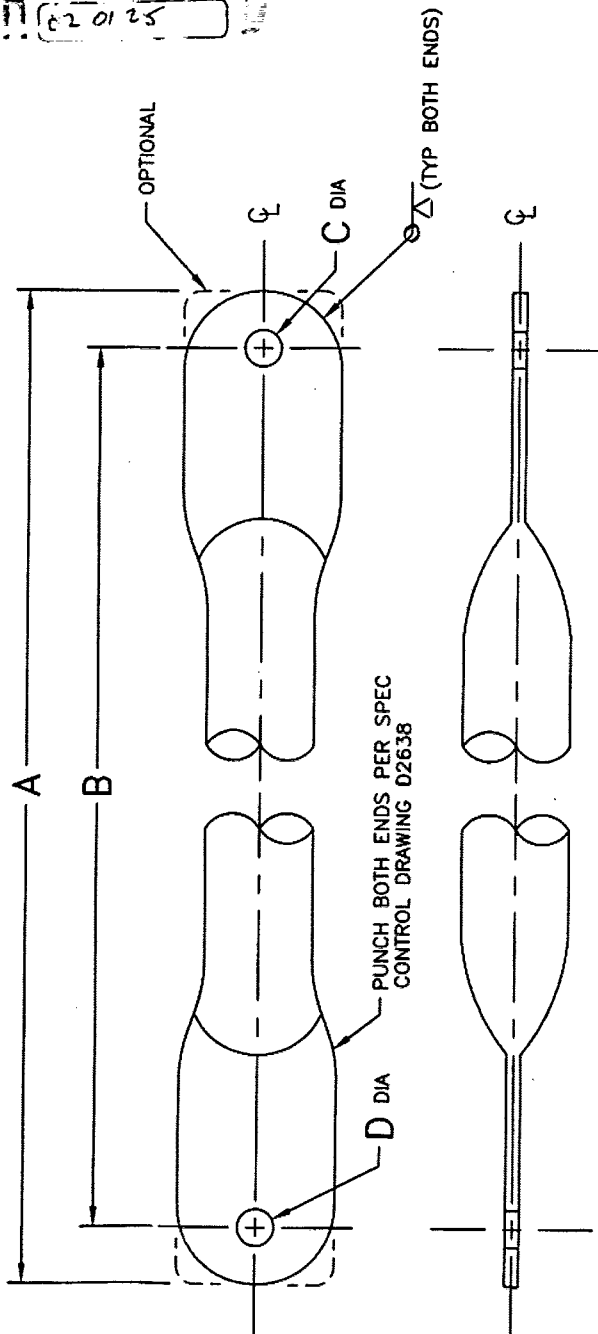
NOTE: Date & initial all entries

DART



DESIGN <i>CP</i>	DRAWN BY <i>CP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>#</i>	APPROVED <i>#</i>	DRAWING NO. D3084	REV. A SHEET 1 OF 1
DATE 02.01.21		TITLE STRUT	SCALE NTS
A	02.01.21	NEW ISSUE	

RELEASED
02 01 25



	A	B	C	D
D3084-1	37.18	36.38	0.257	0.323

NOTES:
1. MAKE PER TEMPLATE DT3084-XX WHERE XX IS THE RESPECTIVE DASH NUMBER
2. MATERIAL: 6061-T6 (WW-T-700/6) SEAMLESS TUBE Ø0.750 x 0.058 WALL
3. WELD ENDS PER DART QSI 004 AND GRIND FLUSH
4. FINISH: POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
5. TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
6. ALL DIMENSIONS ARE IN INCHES

UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 47295

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